

Page 1

Tuesday, August 31, 2010 9:51:41 AM

Item ID:

D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 10.00 Req'd Qty: 10.00



Cust Item ID: Customer:

Reference:

Approvals:	Proces

QC:

Revision Nbr

Operation

Description

Date: 10-8-3/ Tooling:

Date:

SPC (Y/N):

Accept

Run Hours

Set Up/

Tool ID

Date:

Date:

Tool # Plan Code

Accept Qty

Reject Qty

B10-8-31

Run

Setup Start

Stop

Start

Stop

Reject Number

Insp. Stamp

Draw Nbr

D3494 Rev C

100

Sequence ID/

Work Center ID

Waterjet

FLOW CNC Waterjet

304.002

Memo

1-Cut as per Dwg

Dwg Rev:_ Prog Rev:____

2-Deburr if necessary

0.00

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

皮(0-8-3)

Wor	k O	rder	ID	61	657
77 U I	$\mathbf{n} \mathbf{v}$	luci	11/	\ <i>7</i>	W.7/

Tuesday, August 31, 2010 9:51:41 AM



Page 2

Item ID:

D3494-1

Revision ID:

Stub Cover Item Name:

Start Date:

8/31/2010



Accept



Setup Start

Stop



Required Date: 9/7/2010

Start Qty: 10.00 Req'd Qty: 10.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Date:_____

Tooling: SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Memo

Set Up/ **Run Hours**

0.00 Scolustzi

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

130

Brake NC

Brake NC

Bend as per dwg

80 00/09/03

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

5,0109/00

Tuesday, August 31, 2010 9:51:41 AM



Page 3

Item ID:

D3494-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Stub Cover

8/31/2010

Start Qty: 10.00

Req'd Qty: 10.00

Customer:

Cust Item ID:

Reference:

			,	
A	nn	ro	va.	s:

Process Plan: _____ Date: ____ Tooling:

Date:

Date: ____

Run Start

Reject

Qty

Stop



Required Date: 9/7/2010

Operation

Description

QC: _____ Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept **Qty**

Reject Number Stamp

Insp.

Sequence ID/ **Work Center ID**

144

Large Fab

Large Fab

Memo

1- WELD

2- GRIND AS PER DWG

Weld per dwg A/R S.S. rod Batch. MIU 649

0.00

0.00

15.00.01

146

QC

QC10- Inspect visual per QSI004- ground welds

s woodas

Memo

Memo

Quality Control

147

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Siologlas

Tuesday, August 31, 2010 9:51:41 AM



Page 4

Item ID:

D3494-1

Accept

Setup Start

Stop

Stop



Revision ID:

Start Date:

Item Name:

Stub Cover

8/31/2010

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvais:

Process Plan:

Date:

Tooling:

Tool ID

Date:

Run Start

Sequence ID/

Required Date: 9/7/2010

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Accept Qty

Reject Oty

Reject Insp. Number Stamp

Work Center ID

150

Powdercoat

Powder Coating

Operation

Description /// 1/2588 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

START. 11:35

Memo OJENT. 3300 FINISH. 12:05 Set Up/

Run Hours, 10-9-23.

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

0.00

170

Memo

Identify as per dwg & Stock Location

0.00

0.00

(10/1/24 (O)

Packaging

Packaging

Tuesday, August 31, 2010 9:51:41 AM



Page 5

Item ID:

D3494-1

Accept -

Setup Start



Revision ID:

Item Name: Stub Cover

Required Date: 9/7/2010

Start Date:

8/31/2010

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:

Run

Accept

Start

Stop



QC:

Date:_____

SPC (Y/N):

Date:_

Tool # Plan

Code

Stop

Sequence ID/

Work Center ID

180

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Qty Qty

Reject Reject Insp.

Quality Control

Memo

0.00

Picklist Print

Tuesday, August 31, 2010 9:51:46 AM

Work Order ID: 61657

Parent Item: D3494-1

Parent Item Name: Stub Cover



Start Date: 8/31/2010

Required Date: 9/7/2010

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-05-18 JLM

IPP rev B ecn 888 06.12.13 EC

add welding DD 10.03.03 verifie by:EC

chg design EC verified by:DD

IPP Rev:C

Ipp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA	 	Purchased	No		100	sf	82.9000	0.72	7.578947			
304/316 Sheet .063									<u> </u>	B 10-	8-31	

Location	Loc Oty	Loc Code	
MAT20	82.9		
115440	82.9		115-44

DART AEROSPACE LTD	Work Order:	61657
Description: Stub Cover	Part Number:	D3494-1
Inspection Dwg: D3494 Rev: £ D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype)
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	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	0.208	+/-0.010	1368	*		V 1302	
	0.363	+/-0.010	366	×			
	0.766	+/-0.010	1765	y			·
2.53	g <u>2.568</u>	+/-0.010	2.436	*			
6.97	g - 6.318	+/-0.010	6.786	¥			
8.03	9 & 119	+/-0.010	8.041	٧			
8.43	7 8 :523	+/-0.010	8.436	<i>x</i> 6			
8.80	5 -8 -885	+/-0.010	8.811	مع			
1.83	4 :871	+/-0.010	1.831	*			
326	3.307	+/-0.010	3.758	≥			
3.604	3.643	+/-0.010	3.609	سا			
	3.943.940	+/-0.010	3.933	*		i	
7.887	Z 926	+/-0.010	7.883	X			
9.317	_9 .356	+/-0.010	9,323	*			
11.149	11-228	+/-0.010	11.155	*			
	0.060	+/-0.010	1058	¥			
	τ						

Measured by:	Audited by	: 8	Prototype Approvai:	N/A
Date: (0-8-	Date	10/08/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ/DD	
В	10.02.18	Dimensions updated per Dwg Rev C	KJ KJ	M

Dart Aerospace Ltd

W/O:			RK ORDER CHANG	SES			` \	
DATE	STEP	PROCEDURE CHANGE		IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1 Tourivige	
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA :	Date: _	
Resolution:			Disposition	n:	QA: N/C Cld	osed:	Date: _	
NCR:		\	WORK ORDE	R NON-CONFORM	ANCE (NCR)		
DATE	OTED	Description of NC	Description of NC Corrective Action S			Verification	ion Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								
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			`					

NOTE: Date & initial all entries

[•] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



